



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBST2120-15
Job Sheet 171623



Part No: RBST2120-15

Job Qty: 6 ea *10*

Part Name: Locating Pin



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/6/18

Job Tracking No:

Due Date: 2/16/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: RBST2100 REV.7 IPP REV:A 18.01.31 NEW ISSUE JFC VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	6 Ea		2/15/18	0.00	0.00	Start Up Machining-4		
110	CNC Lathe	6 pcs		2/16/18	0.00	1.50	MORI SL-154		
120	QC	6 pcs		2/16/18	0.00	0.00	QC2		
130	QC	6 pcs		2/16/18	0.00	0.00	QC8		
150	Outsource	6 pcs		2/16/18	0.00	0.00	Outsource12		
160	Packaging	6 pcs		2/16/18	0.00	0.00	Packaging2		
170	QC	6 pcs		2/16/18	0.00	0.00	QC6		
180	Packaging	6 pcs		2/16/18	0.00	0.00	Packaging3		
210	QC21-SA	6 Ea		2/16/18	0.00	0.00			

Part Op 110 - 1-Machine as per FOLIO FB799. FOLIO REV: _____ DWG REV: _____ 2-Deburr
Descriptions: 150 - -Issue P/O to Groupe Altech; PO 029549 -Black oxide finish, MIL-C-13924C Class 1 -Certificate of
Conformity is required

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M1018R0.375	1010-1025 Round Bar .375	.4200 ft (.07 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M1018R0.375	0	24	0

Part Specifications

Specifications could not be found.



Container No: S058989



Part: RBST2120-15

Job No: 171623

Serial No/Batch: S058989

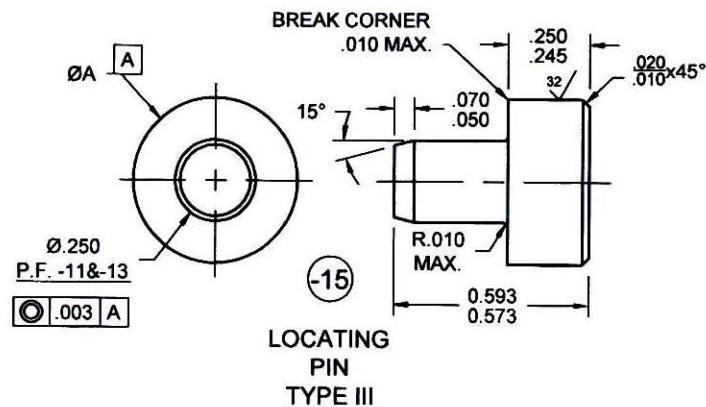
Revision: 7

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

ex 4/5/18 11:50 AM Dart.lajeunesse.marie

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ADDED NOTE TO -1 BODY TO INSPECT BEFORE HEAT TREATING, ALSO CHANGED TOL., OF -1 ROLLER FIXTURE'S ØB, ØC, & ØE FROM +.002 -.000.	2/11/08	WP	DW
2	-15 CHD LOCATING PIN TOLERANCE FROM Ø.2480 Ø.2475 TO Ø.250 P.F. -11 & -13. -11 & -13 CHD FROM Ø.247 Ø.248 TO REAM Ø.290. REMOVED MS14102 & MS14104 CHAMFERED BEARINGS FROM LIST.	2/19/08	WP	GE
3	ADDED KST2128 & KST2162. -13 REMOVED 25° ANGLE FROM SECONDARY SEAT AND DELETED ØB DIMENSION. ADDED QTY TO -13 & -15 CHART.	4/22/08	WP	DW
4	-5 CHD ROLLER RADIUS FROM .005 - .010, TO .015 - .020, -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. CHD -7 SLEEVE TO -7 GUIDE.	7/7/08	WP	DW
4A	CHD T/N FROM KST2100.	11/19/09	RJC	
5	CORRECTED ERROR -3 WAS .165 NOW .172 FOR ROLLER CLEARANCE. ADDED REVISIONS TO ALL PAGES.	1/18/10	WP	DW
6	-15 DELETED LOCATING PIN TYPE I PER. R.W.	9/10/13	CFS	GE
7	-15 RBST2128 CHD MATERIAL SIZE FROM Ø5/8 X 5/8 TO Ø3/4 X 5/8 & RBST2162 FROM Ø3/8 X 5/8 TO Ø1/2 X 5/8.	11/5/13	JAG	GE



NOTES:

- BREAK ALL SHARP CORNERS (.015/.03).

TOOL #	ØA +.000 -.002	PIN TYPE	QTY.	MATERIAL
RBST2120	.310	III	2	1018 RND. BAR Ø3/8 x 5/8
RBST2128	.622	III	1	1018 RND. BAR Ø3/4 x 5/8
RBST2162	.372	III	1	1018 RND. BAR Ø1/2 x 5/8

RED BARN MACHINE TITLE RBST2100 SERIES TRI-ROLLER SWAGING TOOL; LOCATING PIN DWG NO. TOOL# (see chart)-15 REV 7		DRAWN BY: PERRITT APPROVED: <i>D. Mott</i> HEAT TREAT: BLACK OXIDE FINISH SPEC: USED ON BEARING SEE Pg. 1
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5° UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING
SCALE NTS	DATE 1-23-08	SHEET 9 of 9



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO039549

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO039549
PO Date: 4/9/18
Due Date: 4/23/18
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	172434	269T9205-5	Stop -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	4/23/18	4 pcs	0 pcs	4 pcs	\$3.42857/pcs	\$13.71
2	172907	RBE350A93-5300-00-1	Fan Extractor -Issue P/O to Groupe Altech: P/O -Cadmium plating, QQ-P-416F TYPE II, CLASS II -Color; Yellow -Certificate of Conformity is required	Firmed	4/23/18	2 pcs	0 pcs	2 pcs	\$87.50/pcs	\$175.00
3	173775	RBEM711V1000101-1	Cowling Plate -Issue P/O to Groupe Altech: P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Certificate of Conformity is required	Firmed	4/23/18	4 pcs	0 pcs	4 pcs	\$22.50/pcs	\$90.00

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Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	175313	RBST1009-9	Pin Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	4/23/18	7 pcs	0 pcs	7 pcs	\$3.42857/pcs	\$24.00
						✓ 7x		At 18/04/12		
5	173100	RBST2854-15	Locating Pin -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	4/23/18	4 pcs	0 pcs	4 pcs	\$3.42857/pcs	\$13.71
						✓ 4x		At 18/04/12		
6	173101	RBST2854-17	Locating Pin -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	4/23/18	10 pcs	0 pcs	10 pcs	\$3.42857/pcs	\$34.29
						✓ 10x		At 18/04/12		
7	171623	RBST2120-15	Locating Pin -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	4/23/18	10 pcs	0 pcs	10 pcs	\$3.42857/pcs	\$34.29
						✓ 10x		At 18/04/12		
Grand Total:										\$385.00
Order Notes										
Procurement Quality Clauses A005 right of entry A012 chemical and physical test report A016 personnel qualification A017 raw material identification (as applicable) A022 Apical Processing A024 process certifications A026 certification of material conformance A041 quality management system A042 dart notification by supplier A043 retention of quality documents A048 counterfeit parts avoidance, detection, mitigation and disposition program A049 supplier awareness Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.										

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Certificat de Conformité / Certificate of Compliance

(008271-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

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Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
11-Apr-2018		Aman		039549				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	269T9205-5 Rev.	269T9205-5 BLACK OXIDE FINISH MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	4	4	0	0	0
4	RBST1009-9 Rev.	RBST1009-9 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	7	7	0	0	0
5	RBST2854-15 Rev.	RBST2854-15 BLACK OXIDE FINISH MIL-C-13924C CLASS 1	BLACK-OXIDE CH	4	4	0	0	0
6	RBST2854-17 Rev.	RBST2854-17 BLACK OXIDE FINISH MIL-C-13924C CLASS 1	BLACK-OXIDE CH	10	10	0	0	0
7	RBST2120-15 Rev.	RBST2120-15 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	10	10	0	0	0

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Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.